

140219

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

35

Cust Item ID:

35

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

110		0.00			
110					
Mill Conv	Memo	0.05			
Conventional Milling Machine	1- CUT AS PER DWG 2- Mill end of tube as per dwg 3- DEBURR AS PER DWG				
120	QC2- Inspect parts off machine FAI/FAIB	0.00			
120					
QC	Memo	0.01			
Quality Control					
125	QC8- Inspect parts - second check	0.00			
125					
QC	Memo	0.01			
Quality Control					

Work Order ID 140219***140219***

Page 2

Friday, January 22, 2016 12:58:41 PM

Item ID: 647.7714 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Tube
Start Date: 12/17/2015 Start Qty: 35.00 ***35*** Cust Item ID:
Required Date: 12/17/2015 Req'd Qty: 35.00 ***35*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>LLK114</u>	0.00							
130						<u>35</u>	<u>EL</u>	<u>16-2-1</u>	
Packaging	Memo	0.01							
Packaging	***Stock in large fab*** WA001								
140	QC21- Final Inspection - Work Order Release	0.00							
140						<u>MLJ</u>	<u>FEB 02 2016</u>		
QC	Memo	0.06							
Quality Control									

MLJ FEB 02 2016

Picklist Print

Friday, January 22, 2016 12:58:39 PM

Page 1

Work Order ID: 140219

140219

Parent Item: 647.7714

647 7714

Parent Item Name: Strut Tube

Start Date: 12/17/2015

Required Date: 12/17/2015

Start Qty: 35.00

Required Qty: 35.00

Comments: IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.500W.083		Purchased	No				f	41.6560		22.10526			
M4130NT0 500W 083									**				
4130 RD tube .500 x .083W													

Location

Loc Qty

Loc Code

MAT032

41.656

M133597

1.656

M133850

20

M134001

20

20.390

1.656

18.734

J.C. 16-01-25



APICAL INDUSTRIES, INC.
dba DART AEROSPACE

ENGINEERING CHANGE NOTICE NO.

05110

SHEET 1 OF 1

DWG NO. 647.7700

REV: A

PREPARED
BY

A. QUAN

DATE: 08/21/15

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: STRUT ASSY

APPROVED BY:

ENGR

MFG

QC

EFF.

CURRENT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED FINISH CALLOUT AS PER ECR 15-209

SHEET 1, NOTES IS:

ACTION: UPDATE MO & WO

NOTES:

- 1 MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
- 2 MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
- 3 MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
- 4 FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
- 7 WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
- 8 FINISH: CAD PLATE IAW QQ-P-416F CLASS I TYPE II
- 9 MASK THREAD PRIOR TO FINISH

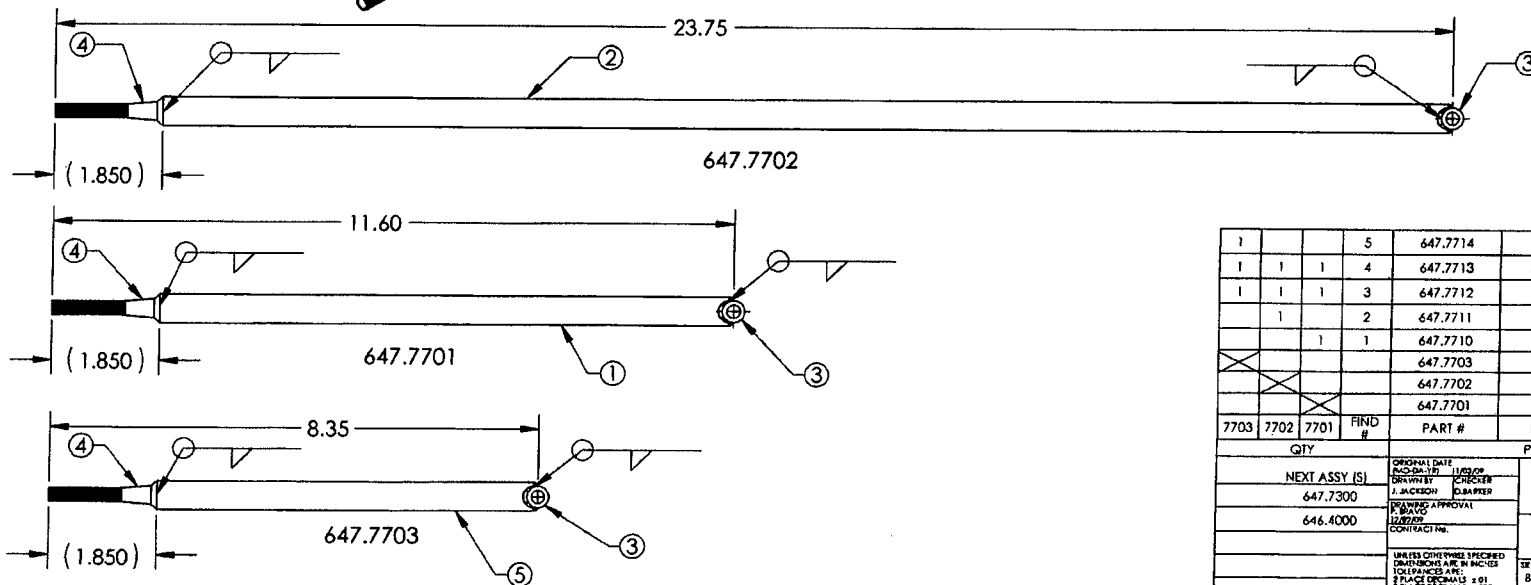
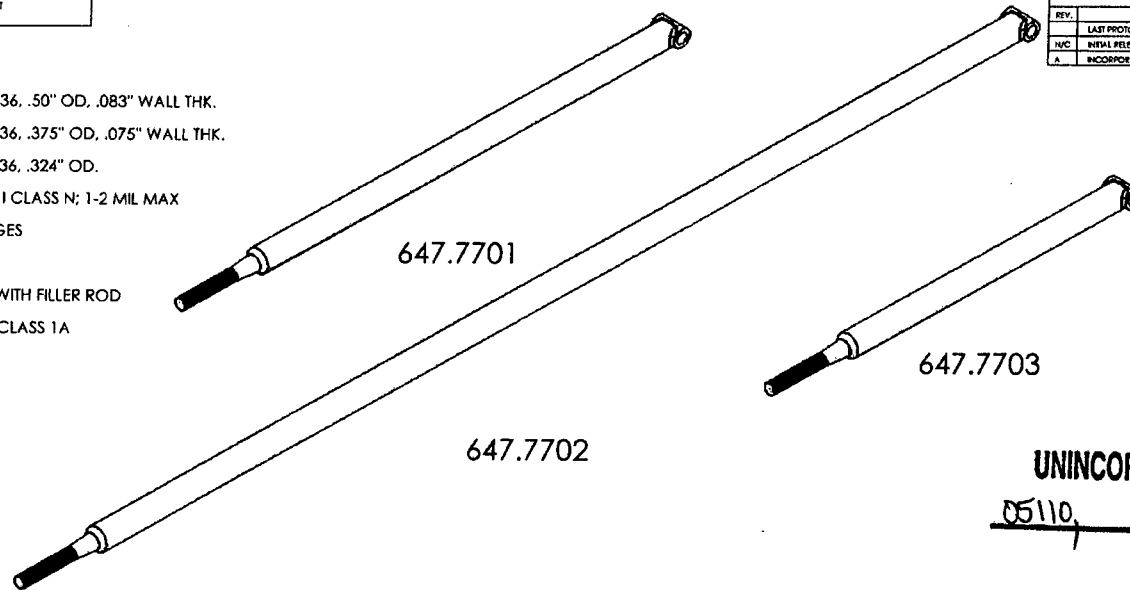
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:					
☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM					
CHANGE CATEGORY					
☐ MAJOR ☐ MINOR					
DER REVIEW REQUIRED					
☐ YES ☐ NO					

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

NOTES:

1. MATERIAL: 4130 STEEL PER AMS-T-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-T-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-T-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219. TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: PPS		JAC
2	INITIAL RELEASE	12/02/89	P. BRAYNO
3	INCORPORATED ECN 04741	11/18/14	P. BRAYNO



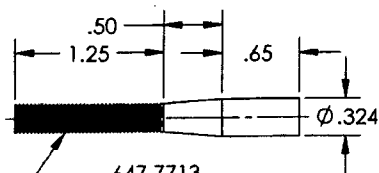
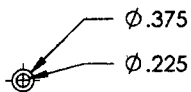
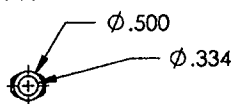
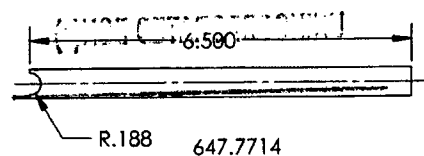
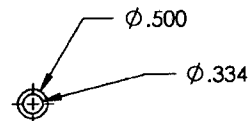
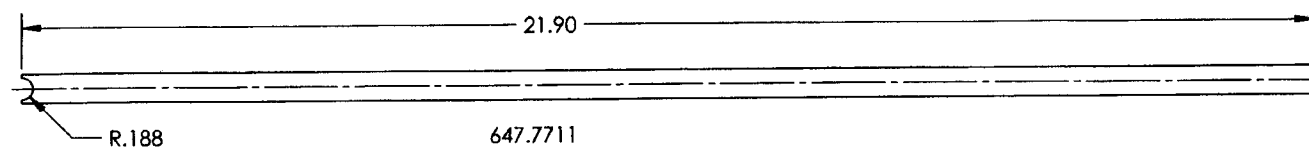
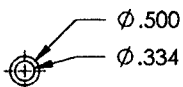
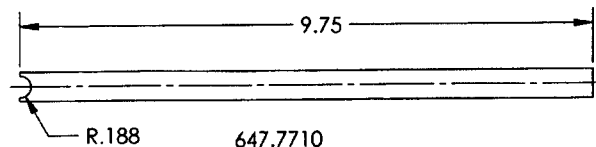
1			5	647.7714	STRUT TUBE	△	
1	1	1	4	647.7713	STRUT THREAD	△	△
1	1	1	3	647.7712	STRUT TUBE	△	
			2	647.7711	STRUT TUBE	△	
			1	647.7710	STRUT TUBE	△	
				647.7703	STRUT ASSY		△ △
				647.7702	STRUT ASSY		△ △
				647.7701	STRUT ASSY		△ △
7703	7702	7701	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE			
647.7300				DRAWN BY			
646.4000				J. JACKSON			
				CHECKED			
				P. BLAKE			
				CONTRACTING			
				UNLESS OTHERWISE SPECIFIED			
				DIMENSIONS ARE IN INCHES			
				TOLERANCES ARE:			
				FRACTIONS DECIMALS ±.01			
				ANGLES ±.5°			
				SCALE NONE			
				SHEET 1 OF 2			

APICAL INDUSTRIES
 2608 TEMPLE HEIGHTS DR.
 OCEANSIDE, CA. 92056-3512 (760)724-5300

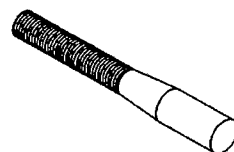
STRUT ASSY

REV. A

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



1/4 - 28 THREAD



ORIGINAL DATE JAN 04-98		APICAL INDUSTRIES	
DRAWN BY J. JACKSON		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL P. BRAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		STRUT ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET 8	REV. A
CAGE CODE 07M26		DWG. NO. 647.7700	SHEET 2 OF 2
SCALE: NONE			